

AAL

Split

Date: Tuesday, 04/11/2008 10:29:37 AM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	BRACKET
Job Number	43184-3	Part Number	D36373
Estimate Number	12967	Drawing Number	D3637 REV B
P.O. Number		Project Number	N/A
This Issue	04/11/2008	Drawing Revision	B
Prsht Rev.	NC	Material	
First Issue	/ /	Due Date	11/11/2008
Previous Run	42823	Qty:	24
Written By		Um:	Each
Checked & Approved By			
Comment	Est Rev:A New Issue 07-07-20 JLM Est Rev:B change to REV.B as per dwg 08-02-11 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M2024T3S050	2024-T3 .050 sheet
	Comment: Qty.: 0.1407 sf(s)/Unit Total : 3.3768 sf(s) 2024-T3 .050 sheet Batch: 107711	IB 8-11-4
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3637 Dwg Rev: B Prog Rev: B	IB 8-11-4
	2-Deburr if necessary	IB 8-11-4
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	IB 8-11-4
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	5/06/04 640 counter
5.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE Form as per Dwg D3637	06/05/05 11/12
		SB 08/11/05
		32

Job Number: 43184

Part Number: D36373

Job Number:



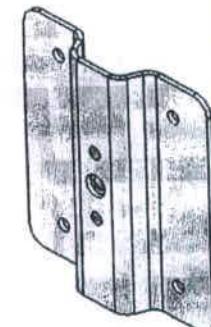
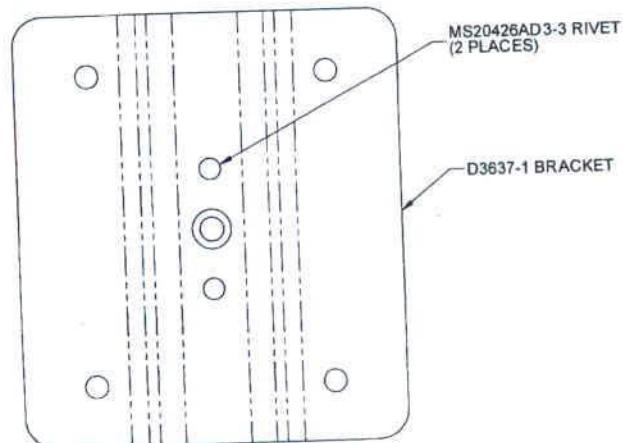
Seq. #:	Machine Or Operation:	Description:
6.0	QC5	INSPECT WORK TO CURRENT STEP
7.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
8.0	QC5	INSPECT WORK TO CURRENT STEP
9.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
11.0	PACKAGING 1	PACKAGING RESOURCE #1
12.0	QC21	FINAL INSPECTION/W/O RELEASE

Comments and handwritten notes:

- Row 6.0: Comment: INSPECT WORK TO CURRENT STEP
- Row 7.0: Comment: SMALL & MEDIUM FAB RESOURCE 1
 - 1- drill holes as per dwg using DT8979
 - 2- c'sink holes as per dwg
 - 3-deburr
- Row 8.0: Comment: INSPECT WORK TO CURRENT STEP
 - 08/11/12
 - ENGIE HFRE001L
 - SB 08/11/12
 - 4
- Row 9.0: Comment: HAND FINISHING RESOURCE #1
 - Chemical Conversion Coat as per QSI 005 4.1
 - M-1
 - 08/11/12
 - 4X
- Row 10.0: Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION
 - 8/11/12
 - Fx
 - 08/11/12
 - 4
- Row 11.0: Comment: PACKAGING RESOURCE #1
 - Identify with P/N and B/N using a permanent fine point marker, then Stock
 - Location: 861
 - 8/11/12
 - 50
 - 4X
- Row 12.0: Comment: FINAL INSPECTION/W/O RELEASE
 - 8/11/13
 - MF 08-11-13

Job Completion:





D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)

D3637-041 PARTS:

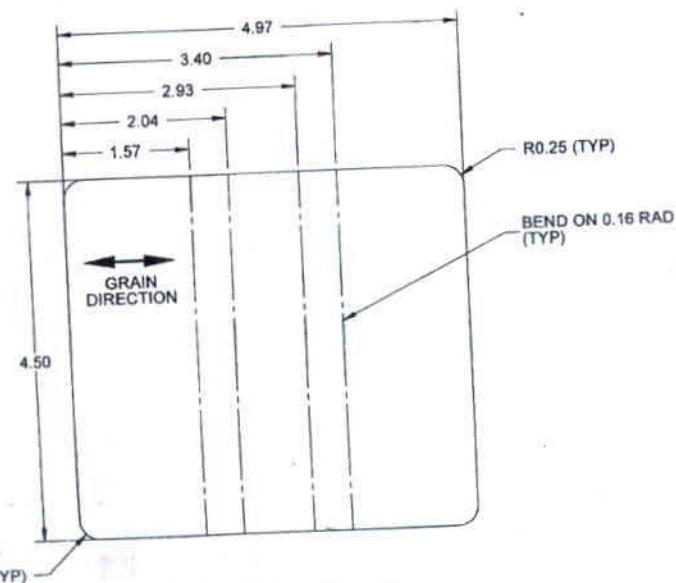
QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

170-2005-109

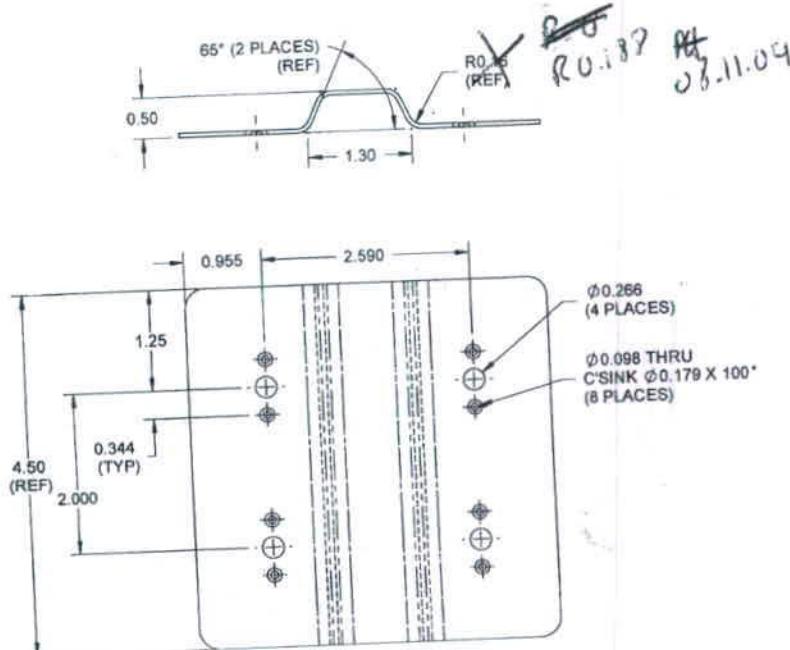
B	FOR D3637-1, 1 15 WAS 1 30 & "REF" REMOVED FROM ANGLE	LE	07.12.18
A	NEW ISSUE; REPLACES G10608, G10602 & G10609	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	DART AEROSPACE LTD	
DRAWN	<i>CE</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>CE</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>CE</i>	D3637	SHEET 1 OF 3
APPROVED	<i>CE</i>	TITLE	SCALE
DE APPR.	<i>CE</i>	BRACKET	1:1
DATE	07.12.18	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



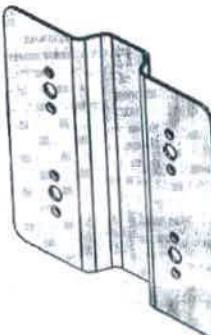
D3637-3F FLAT PATTERN

D3637-3 NOTES:
 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037
 (REF DART SPEC M2024T3S.050)
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: 0.32 lbs

Mo 43184



D3637-3 BRACKET
 (WAS GENEVA P/N G10609-1)



DESIGN	TS	DART AEROSPACE LTD
DRAWN	<i>LE</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>RF</i>	REV. B
MFG. APPR.	<i>CD</i>	DRAWING NO.
APPROVED	<i>IN</i>	D3637
DE APPR.	<i>W</i>	SHEET 3 OF 3
DATE	07.12.18	SCALE
		23
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1.410
 955
 2.540
 955
 1.300



TAEROSPACE LTD

Work Order: 43184

escription: BRACELET

Part Number: D3631-3

Inspection Dwg: D3637-3 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x

First Article

x

Prototype

Measured by:

四

Date: _____

9-11-4

Audited by:

Date:

Prototype Approval:

1

Date:

Rev	Date	Change	Revised by	Approved
A		New issue	KJ/JLM	



WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						

Part No: D3637-3

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: 

Date: 08.11.03

Resolution: _____

Disposition: _____

QA: N/C Closed: _____

Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.11.04	5	RO.16 was crackling	RF 08.11.04	change to RO.18 - NO MORE CRACKLING PRESENT	RF 08.11.04	S ackless	RF QSFZ 08.11.04	S ackless

NOTE: Date & initial all entries

